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D2739
Job Sheet 211100



Part No: D2739

Job Qty: 6 pcs

Part Name: 350 I-Beam



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/3/20

Job Tracking No:

Due Date: 7/24/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per rev E DD ver: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	6 pcs	7/23/20		0.00	6.96	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	6 pcs	7/23/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Handfinish - 1-1 Chemical-B4B	6 pcs	7/24/20		0.00	1.20	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		

DAS
03
9-89

20.7.9



Container No: S286417



Part: D2739

Job No: 211100

Serial No/Batch: S286417

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

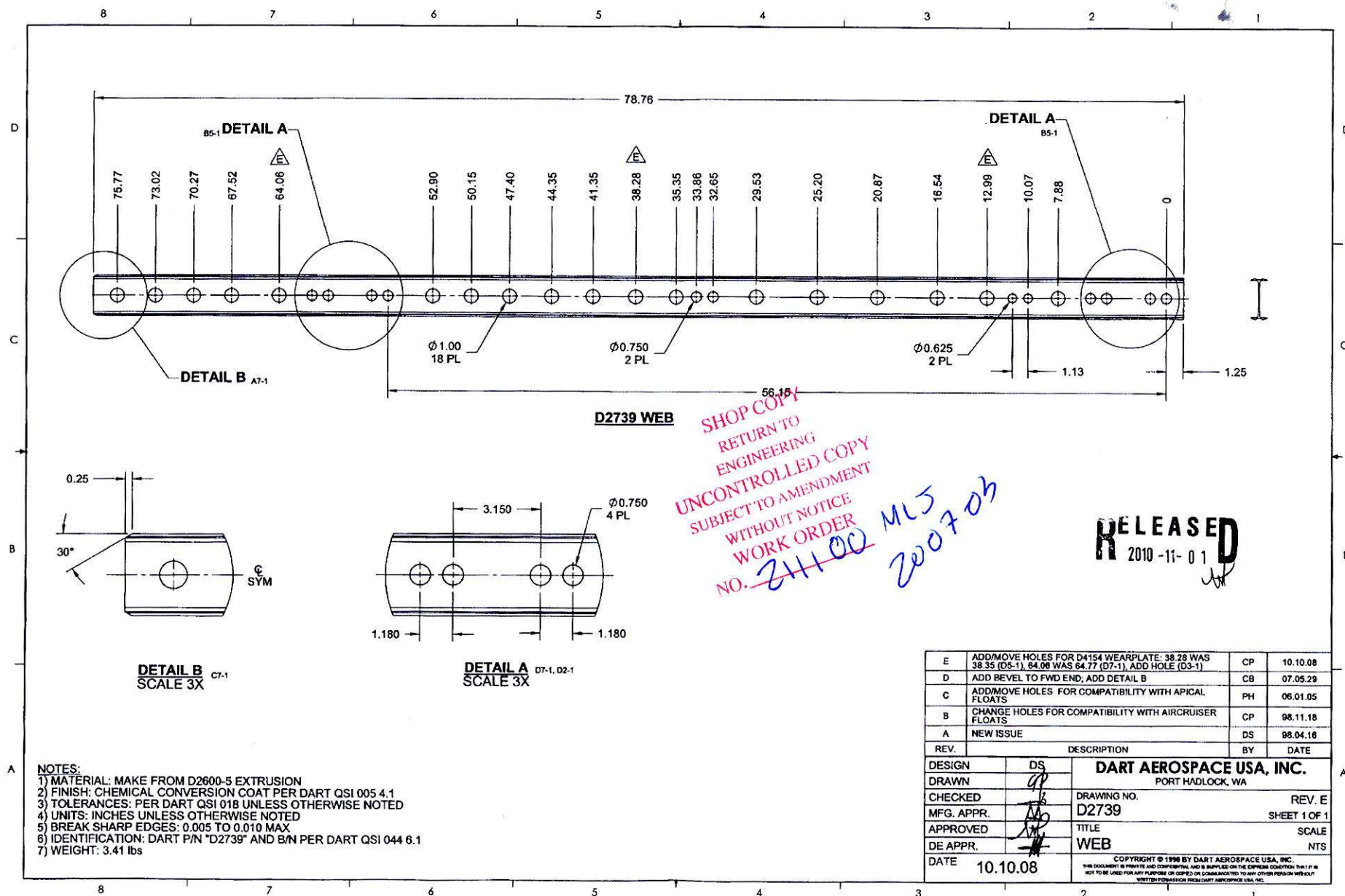
Date: 07/07/20

Plex 7/3/20 1:01 PM Dart.lajeunesse.marie

https://www.plexonline.com/018f57dc-bec7-4745-9b1f-d93175f20287/Plexus_Control/Report_Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=True... 2/4

				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
				QC 7 - 82	
				QC 7 - 87	
140	Packaging 3-1 - Stock - B4B	6 pcs	7/24/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
150	QC 21 - SA	6 pcs	7/24/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
					QC 21 - SA - 77
Part Op 100 - (Skid tubes) 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Descriptions: Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends. 110 - QC5- Inspect part completeness to step on W/O 120 - (Chemical Conversion Coat per QSI005 4.1) 130 - (QC7- Inspect Chemical Conversion Coat) 140 - (Identify as per dwg & Stock Location: <u>LG002</u>) LOCATION : LG002 150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2600-5-108	Extrusion I-Beam Thin	6 pcs (1 ea)	100-Skidtubes - 1	5146203	

Job Allocations					
Operation 100-Skidtubes - 1	Component Part D2600-5-108	Required 6	Inventory 50	Allocated 0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Web	78.760Inches ± 0.030	78.790 78.730		
2	Web	1.180Inches ± 0.010	1.190 1.170		
3	Web	3.150Inches ± 0.010	3.160 3.140		
4	Web	1.180Inches ± 0.010	1.190 1.170		
5	Web	0.250Inches ± 0.030	0.280 0.220		
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle	
7	Web	1.250Inches ± 0.030	1.280 1.220		
8	Web	7.880Inches ± 0.030	7.910 7.850		
9	Web	10.070Inches ± 0.030	10.100 10.040		
10	Web	12.990Inches ± 0.030	13.020 12.960		
11	Web	16.540Inches ± 0.030	16.570 16.510		
12	Web	20.870Inches ± 0.030	20.900 20.840		
13	Web	25.200Inches ± 0.030	25.230 25.170		
14	Web	29.530Inches ± 0.030	29.560 29.500		
15	Web	32.650Inches ± 0.030	32.680 32.620		
16	Web	33.860Inches ± 0.030	33.890 33.830		
17	Web	35.350Inches ± 0.030	35.380 35.320		
18	Web	38.280Inches ± 0.030	38.310 38.250		
19	Web	41.350Inches ± 0.030	41.380 41.320		
20	Web	44.350Inches ± 0.030	44.380 44.320		
21	Web	47.400Inches ± 0.030	47.430 47.370		
22	Web	50.150Inches ± 0.030	50.180 50.120		
23	Web	52.900Inches ± 0.030	52.930 52.870		
24	Web	64.060Inches ± 0.030	64.090 64.030		
25	Web	70.270Inches ± 0.030	70.300 70.240		
26	Web	73.020Inches ± 0.030	73.050 72.990		
27	Web	75.770Inches ± 0.030	75.800 75.740		
28	Web	56.150Inches ± 0.030	56.180 56.120		



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NO. 24100 ML5
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RELEASED
2010-11-01

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					